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D2221

Job Sheet 194829



Part No: D2221

Job Qty: 1 pcs

order 16189

Part Name: Basket Base Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/9/19

Job Tracking No:

Due Date: 5/27/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG REV H IPP Rev:J 05.09.02 Added D3442-1 KJ/JLM IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N 10.06.29 added pressure wash DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	1 pcs	5/27/19	5/27/19	0.00	10.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		cc
							Large Fab - 8		
110	QC 9	1 pcs	5/27/19	5/27/19	0.00	0.00	Large Fab - 9		
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		DAS
							QC 9 - 43		43
120	QC 5	1 pcs	5/27/19	5/27/19	0.00	0.00	QC 9 - 50		9-89
							QC 9 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		DAS
							QC 5 - 43		43
							QC 5 - 49		9-89
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
125	Handfinish - 2-1 Pressure- B4B	1 pcs	5/27/19	5/27/19	0.00	0.35	QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							Handfinish - 2 - 1 - B4B		
	Handfinish - 2 - 2 - B4B						Handfinish - 2 - 2 - B4B		
							Handfinish - 2 - 3 - B4B		
							Handfinish - 2 - 4 - B4B		3K19-5-23

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Container No: S182807



Part: D2221

Job No: 194829

Serial No/Batch: S182807

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Email: Sales@dartaerospace.ca
www.dartaerospace.ca

130 Powdercoat - 2 White GI(S)- B4B	1 pcs	5/27/19	0.00 0.81	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
140 QC 3	1 pcs	5/27/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	4414-5-22
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
150 Packaging 3-1 - Stock - B4B	1 pcs	5/27/19	0.00 0.00	QC 3 - 24	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 -	

DAS
15
9-89

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					B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
160 QC 21 - SA	1 pcs	5/27/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 100 - (Weld per dwg A/R S.S. rod Batch: _____) 1- assemble all ribs and both D2581 in D2221 jig, weld as per Descriptions: dwg D2221 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221 3- tack weld mesh on basket as per dwg D2221 A/R ER316 S.S. Rod Batch: _____ ***PLEASE NOTE SEE DWG*** IF MAKING -141/-041A CUT BUSHING ON BASE BOTH ENDS, OR -143/-043A CUT BUSHING ON ONE SIDE ONLY OF BASKET BASE AS PER DWG

110 - (QC9- Inspect visual per QSI004- Fusion Welds)
 120 - (QC5- Inspect part completeness to step on W/O)
 125 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) *1151749*
 130 - (White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) 1- Plug holes prior to 1ST COAT: START TIME: *3:40*
 OVEN TEMPERATURE: *350* FINISH TIME: *3:55* ***** 2nd coat if necessary ***** 2ND COAT: FINISH TIME: _____
 140 - (QC3- Inspect Part Finish)
 150 - (Identify as per dwg & Stock Location: _____)
 160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2221-1	Rib ✓	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	<i>5032940</i>
D2221-5	Rib ✓	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	<i>5179590</i>
D2221-7	Rib ✓	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	<i>5006413</i>
D2232-3	Basket Hinge ✓	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	<i>5171327</i>
D2235-1	Basket Rib ✓	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	<i>5037237</i>
D2581	Mounting Bracket ✓	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	<i>5178393</i>
D3442-1	Shim ✓	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	<i>157359</i>
D3825-041	Rib Assembly (Basket End) ✓	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	<i>5039313</i>
D3826-041	Rib / Gusset Assembly ✓	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	<i>5058121</i>
D3827-041	Rib Assembly (Inboard) ✓	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	<i>5039984</i>
D3833-1	Mesh (Base End Face)	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	<i>510679</i>
M304EX0.75-16F	Expanded Metal Flat SS	26.6000 sf (26.6 ea)	100-Large Fab - Welded Assy-1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D2221-1	1	6	0
	D2221-5	2	0	0
	D2221-7	1	5	0
	D2232-3	2	10	0
	D2235-1	2	3	0
	D2581	2	32	0
	D3442-1	2	11	0
	D3825-041	2	2	0
	D3826-041	2	4	0
	D3827-041	1	4	0
	D3833-1	2	6	0
	M304EX0.75-16F	27	717	0

Part Specifications

Specifications could not be found.

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